

Date: Monday, 23/03/2009 1:32:14 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET BASE
 Job Number : 45977B
 Estimate Number : 11276
 P.O. Number :
 This Issue : 23/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2330041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2330 REV G
 Previous Run : 44222B Project Number : N/A
 Material :
 Due Date : 30/04/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09.03.23
 Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K
 J
 Est Rev:I 08-09-09 revF as per dwg (ecn 08-522) DD verified
 by:EC
 Est Rev J 09.03.03 09-532 EC verified by:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 26.3970 f(s)/Unit Total : 26.3970 f(s)

3/4" x 3/4" x 0.065 wall 304/316 SS tubing.

Batch: M1111-08

SAD 09-03-31

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

SAD 09-03-31

3.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2012-107 Clevis

Batch:

331101

Cpl 09.04.04

PTC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2330-041 PAR #: N/A Fault Category: Large Fab NCR: (Yes) No DQA: ls Date: 09-07-07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ls Date: 09-08-09

NCR: <u>45977B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-03	16.0	D2012-107 WAS WELDED IN WRONG LOCATION. RC- LACK OF ATT	<u>ls</u> 09/04/03	REMOVE and SCRAP PART and REPLACE	<u>Cpl</u> 09-04-03	<u>ls</u> 09-04-06	<u>ls</u>	<u>ls</u>
09-06-04	3.0 ↓ 6.0	Upon closing J16WB, it was noticed that a D2012-117 was used in error, instead of a -107. R.C.: LDA	<u>ls</u> 09/06/04	Parts are very similar, i tle -107 that was used is close to the -107 dims. Part was made to the max tolerances. Acceptable this time only,	<u>ls</u> 09-06-04	<u>ls</u> 09-06-04	<u>ls</u> 09/06/04	<u>ls</u> 09-06-04
			↓	BUT re-work the bracket to open the 0.197 hole to 0.257. Touch-up hole with white Imron	<u>Cpl</u> 09-06-04	<u>ls</u> 09-06-04	↓	<u>ls</u> 09-06-04

NOTE: Date & initial all entries

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Drawing Name: 206B BASKET BASE

Job Number: 45977B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D22351

Basket Rib



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Basket Rib

B46627 → 1 B46771 → 3

CPL09-04-06

5.0

D22521

Frame



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Frame

N/A

6.0

D22527

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Frame

N/A

7.0

D22531

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Batch:

B40894

CPL09-04-06

8.0

D2254

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2254

Lug

339801

CPL09-04-06

9.0

D23273

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2327-3

Bushing

B41274 39560

CPL09-04-06

10.0

D23301

Frame



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Frame

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		WELDER SET TO 210°F						

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Drawing Name: 206B BASKET BASE

Job Number: 45977B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D23305

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Frame

N/A

12.0

D23307

Frame



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Frame

N/A

13.0

D2581

Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2581

Mounting Chancel

345684

PLC 09-04-06

14.0

D37481

Hinge Half



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)
Hinge Half

345605

PLC 09-04-06

15.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 31.5000 sf(s)/Unit Total: 31.5000 sf(s)

Pick:

Qty Part Number

Description

Batch

30 sf

M304EX0.75-16F Expanded Metal

M11173

SAM 09-04-07

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig, Deburr as required

A/R SS ROD

Batch:

M106762

PLC 09-04-06 previous page

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45977B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

POWDER COATING

POWDER COATING



M110939



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1st coat

8:40

2nd coat

Start Time: 9:30

oven Temp: 400°F

Finish Time: 10:00

09/04/11

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP 45977

9/4/11

50

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/06/05
mf
09-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

G

G

G

G

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G/R MP

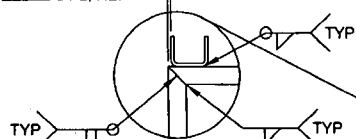
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.080.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	J/B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J/B		
CHECKED	PH	DRAWING NO.	REV. G
MFG. APPR.	W	D2330	SHEET 1 OF 6
APPROVED	W	TITLE	SCALE
DE APPR.	W	BASKET ASSEMBLY (206B)	NTS
DATE	09.02.05	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS ORIGINALLY SUBMITTED. ALL RIGHTS RESERVED.	

8 7 6 5 4 3 2 1

G 10 0.13
2 PL. REF



WELD ALL JOINTS
AS SHOWN

G D2252-1

D2327-3
REF
SEE DETAIL G
A2-5

10 42.00
REF

D3749-1
3 PL G

G D2252-7

D2330-15

G D2252-1
G D2252-7

25.50
REF

G D2330-1

33.00

24.00

D2581

TYP

D2581

24.00

34.50

24.00
REF

9

9

9

D3749-1
REF G

A

84.00±0.13 G

A D6-5

D2330-043 LID FRAME

RELEASED
07/2/87

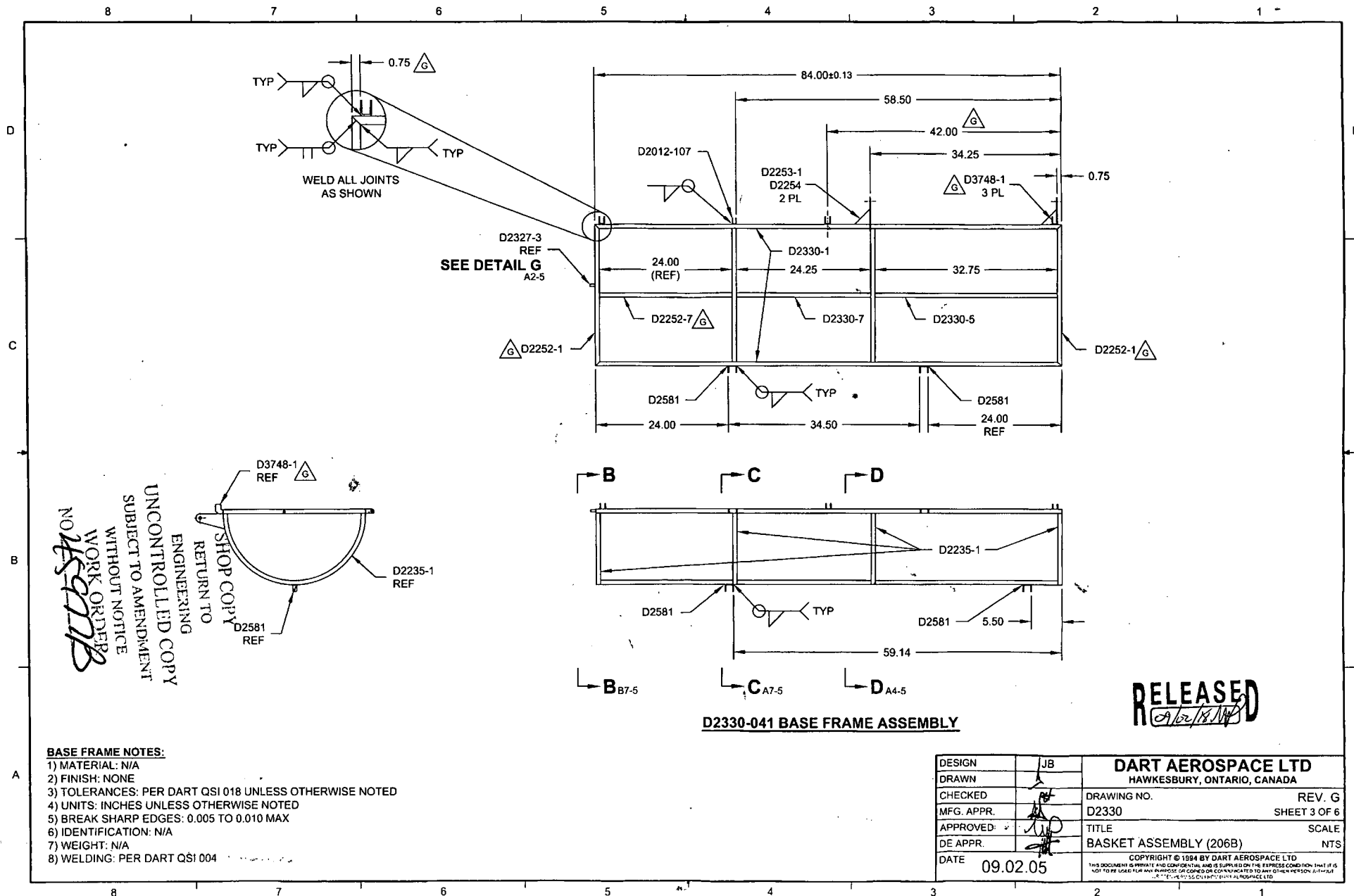
LID FRAME NOTES:

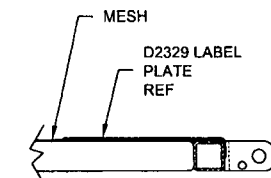
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY G

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MFG. APPR.		D2330	SHEET 2 OF 6
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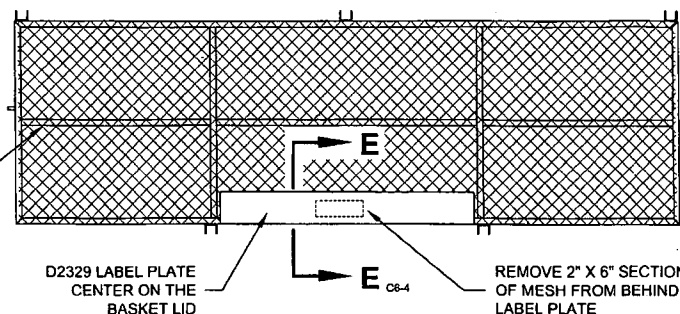
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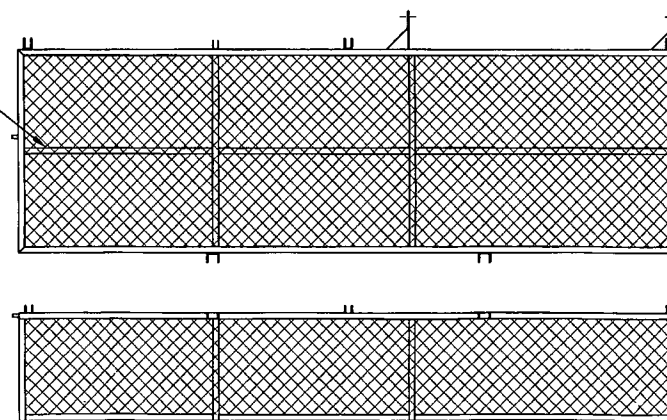


SECTION E-E C3-4
VIEW ROTATED 90° CCW

TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY



D2330-043
REF

TRIM MESH LOCALLY
AS REQUIRED

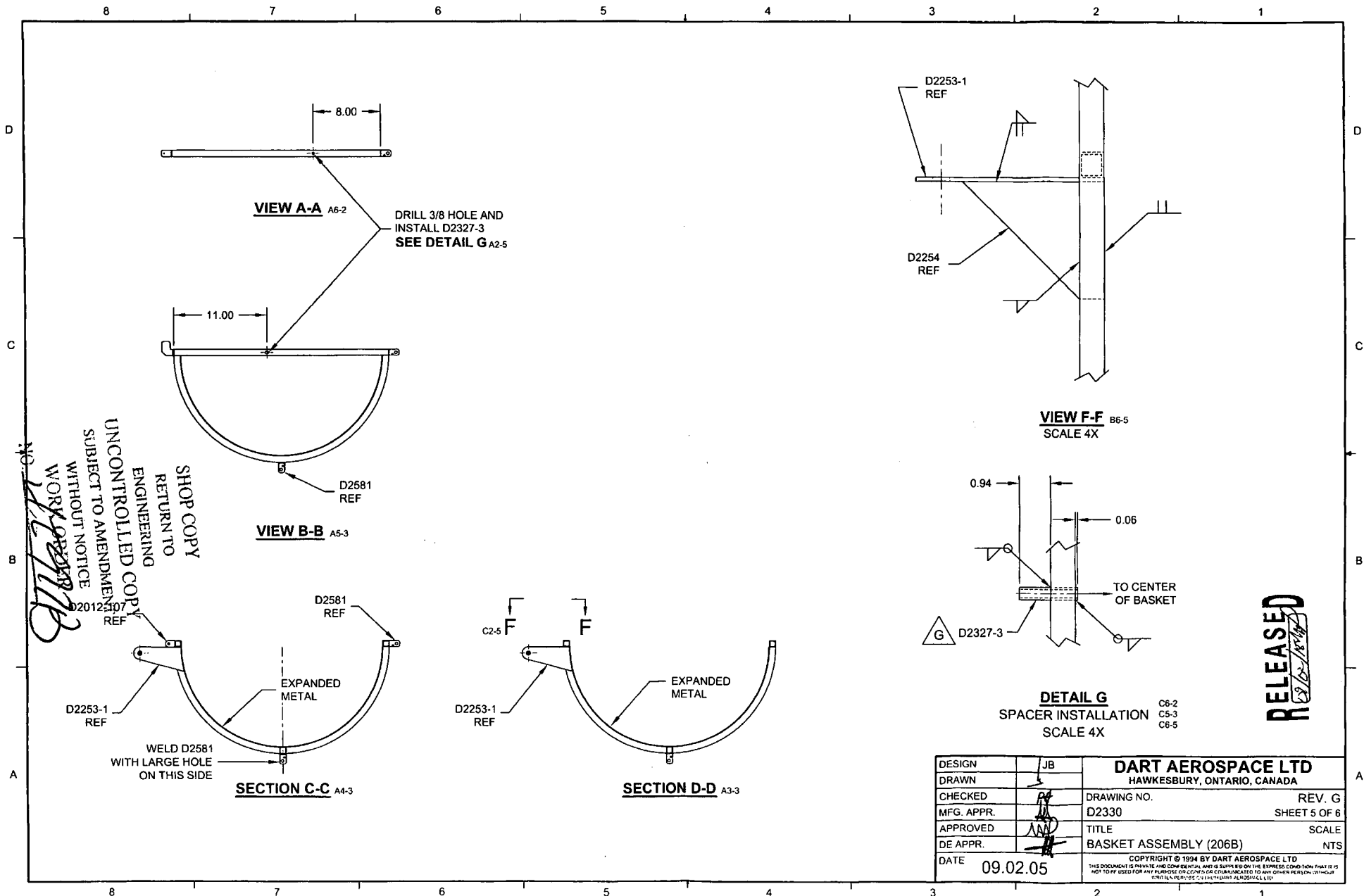
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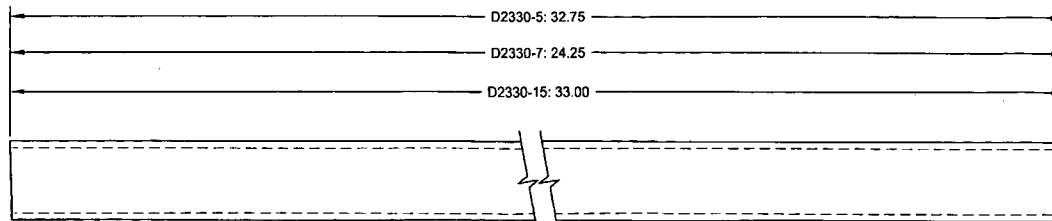
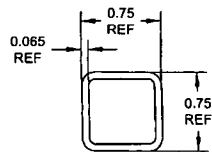
ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

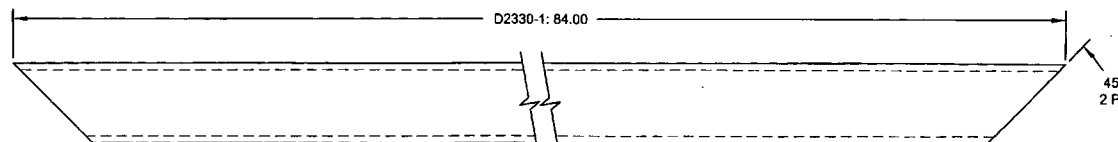
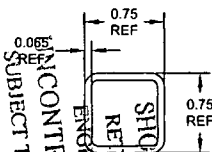
DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2330	SHEET 4 OF 6
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RELEASED
07/02/18








D2330-5 FRAME
D2330-7 FRAME
D2330-15 FRAME



D2330-1 FRAME

RELEASED
 9/2/18

- NOTES:**
 1) FRAME MATERIAL: SEE SHEET 1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

DESIGN	JB	DART AEROSPACE LTD	
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